

Date: Thursday, 8/30/2007 3:51:27 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 34369		
Estimate Number	: 10533		
P.O. Number	: <i>N/A</i>	Part Number	: D2573
This Issue	: 8/30/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2573 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 33042	Material	: <i>N/A</i>
Written By	:	Due Date	: 9/21/2007 Qty: 8 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: 1 As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
7075-T7351 8.25X7.75X2.5  
Make from D6101-007 billet for D2573  
Ensure that grain is along 7.75" length  
Batch No: *331389*

*SC 07-09-26* *(8)*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. *34369* Double check by *SC*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

*ML 07/10/02* *8*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2573 & D2574

*ML 07/10/02* *8*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ML 07/10/02* *8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/10/03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H.

07/10/03

8X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

U 07-10-03

8X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/04 8

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST342

ST433

07/10/04 8

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/04 8

Job Completion



U 07-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34369
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	0.440	0.440	0.446	0.440		
B	1.745	1.755		1.749	1.750	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.506	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	7.998		
F	0.490	0.510		0.500	0.502	0.502	0.504		
G	0.257	0.262	<del>DT8683</del>	0.258	0.258	0.258	0.258		
H	0.375	0.380	<del>DT8684</del>	0.377	0.377	0.377	0.376		
I	0.490	0.510		0.502	0.502	0.502	0.501		
J	1.174	1.184		1.179	1.179	1.178	1.178		
K	0.558	0.578		0.568	0.569	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.178	1.178		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.499	2.499	2.500	2.500		
O	4.119	4.129		4.123	4.126	4.121	4.121		
P	0.115	0.135		0.124	0.125	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.249	0.253	0.254		
S	0.115	0.135		0.128	0.127	0.121	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.229		
V	0.230	0.250		0.236	0.240	0.242	0.244		
W	0.115	0.135		0.127	0.128	0.126	0.128		
X	0.308	0.313		0.311	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.761	0.760		
Z	0.352	0.372		0.362	0.360	0.360	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.623	0.632	0.625	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.252	0.254		
AE	1.500	1.520		1.513	1.515	1.512	1.510		
AF	0.115	0.135		0.123	0.120	0.126	0.125		
AG	0.240	0.280		0.255	0.255	0.250	0.260		
AH	0.240	0.260		0.248	0.247	0.254	0.254		
AI	2.000	2.020		2.003	2.005	2.002	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	me
Date:	07/10/01

Audited by:	JL
Date:	07/10/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34369
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H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
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AH	0.240	0.260		0.249	0.251	0.249	0.251		
AI	2.000	2.020		2.005	2.001	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

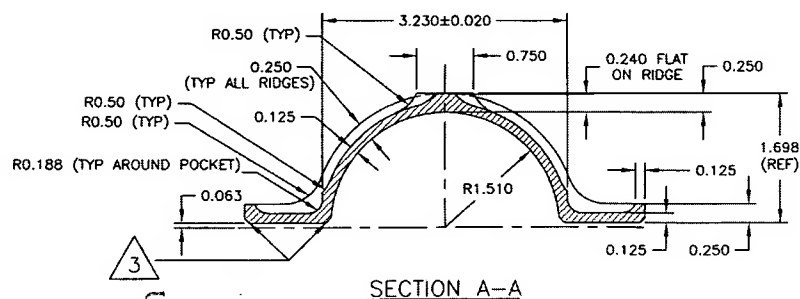
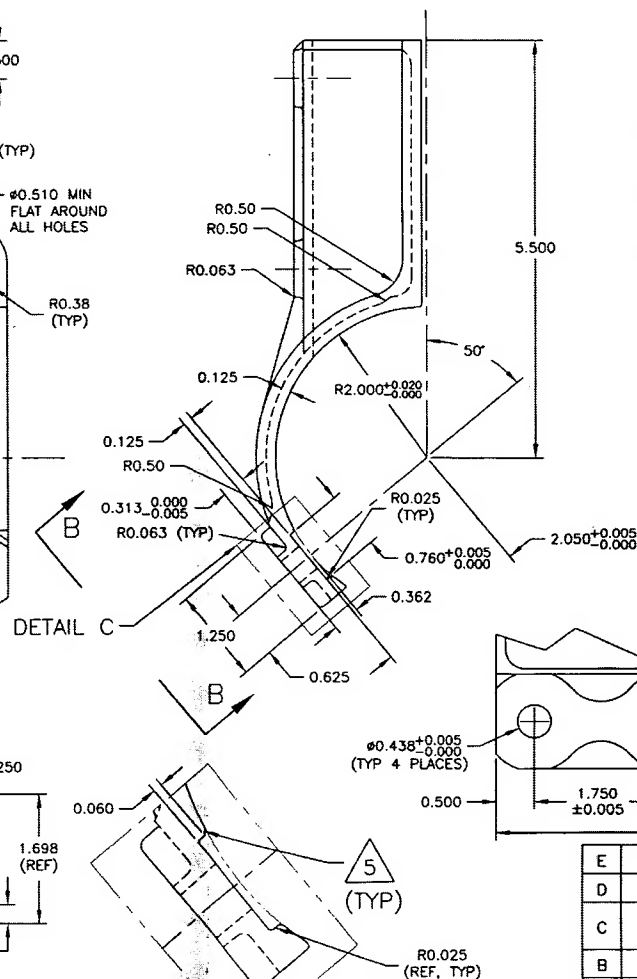
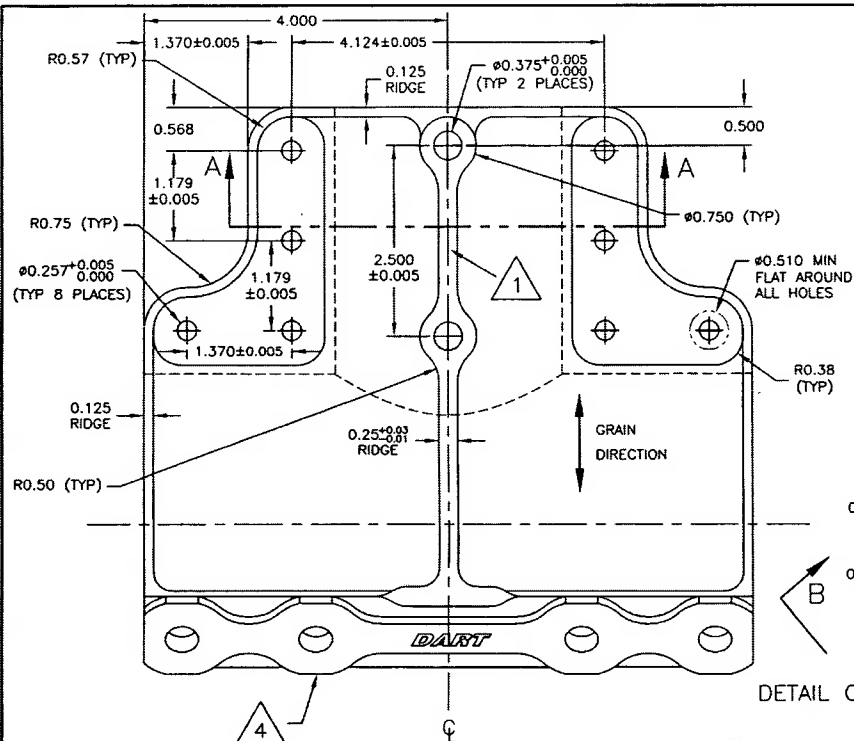
Measured by:	One
Date:	07/10/02

Audited by:	J.L
Date:	07/10/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06 #

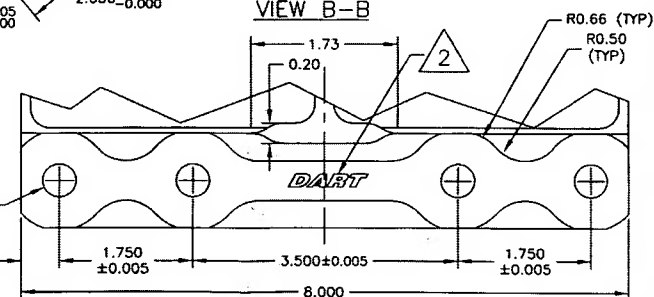
DETAIL C  
SCALE 4:3

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  
3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
4 CHAMFER 0.063" x 45° ALL AROUND  
5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

## VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. 02573
		TITLE OUTER AFT SADDLE
		SCALE 2:3

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**DART**DART AEROSPACE LTD.  
HAMPSHIRE, ONTARIO, CANADA

REV. E

SHEET 1 OF 1

SCALE

2:3

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NO. 34369

